Work Order ID 62707

Wednesday, October 06, 2010 3:21:21 PM



Page 1

Item ID:

D3535-15

Accept

Setup Start



Revision ID:

Start Date:

Item Name:

Wearshoe

10/6/2010

Start Qty: 8.00 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Tooling:

Date:

Run

Start

Stop

Stop



Required Date: 10/15/2010

QC:

Date:

SPC (Y/N):

Date:

Accept

Reject

Insp.

Work Center ID

Sequence ID/

Operation

Revision Nbr

Rev B

Set Up/

Tool ID

Tool # Plan Code

Reject

Stamp

Draw Nbr

Description

Run Hours

Qty

Qty

Number

D3535 100

Waterjet

FLOW CNC Wateriet

304, 040

FLOW WATER JET

Memo

1-Cut as per Dwg D3535 □Dwg Rev:

0.00

0.00

B □Prog Rev: **B** □2-

110

QC2- Inspect parts off machine FAI/FAIB

Deburr if necessary

0.00

Quality Control

Memo

0.00

B10-10-14

B10-10-14

120

QC8- Inspect parts - second check

Quality Control

Memo

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W/O: WORK ORDER CHANG					SES			7			
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:						
Resolution:			Disposition	QA: N/C C	losed:	Date: _					
NCR:		,	WORK ORD	R NON-CONFORM	ANCE (NCF	₹)					
DATE	CTED	Description of NC			tion B	Verificat	tion Approval	Approval			
DATE	SIEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign a	& Section		QC Inspector			
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W	ork	Or	der	ID	62707
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Wednesday, October 06, 2010 3:21:21 PM



Page 2

Item ID:

D3535-15

Accept

Setup Start

Revision ID:

Item Name:

Wearshoe

Start Date: 10/6/2010 **Required Date: 10/15/2010**

Start Qty: 8.00

Req'd Qty: 8.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:_____

Tooling:

Date:

Run Start

Reject

Qty



Date:_____

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool # Plan

Code

Stop

Reject

Stop



Number Stamp

Insp.

Sequence ID/ **Work Center ID**

130

Brake NC Brake NC

NC BRAKE

Operation

Description

0.00

0.00

1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326□2-Form joggle as per Dwg D3535 using Jig DT8158□3-Identify as D3535-15

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Accept

Qty

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

□OV5N TEMPERATURE:

De 10-10-19

Dart Ae	rospace	Ltd					***	, ,
W/O:			WO	RK ORDER CHANGE	ES			1.
DATE	STEP	PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	Re	esolution:	_ Disposition	ı:	QA: N/C CI	osed:	Date: _	
NCR:		W	ORK ORDE	R NON-CONFORMA	NCE (NCR)		
		Description of NC		Corrective Action Section	on B	Verification	Approval	Approval
DATE	STEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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			.					

DATE STEP Description of NC Section A Initial Chief Eng Chief Eng

Work Order ID 62707

Wednesday, October 06, 2010 3:21:21 PM



Page 3

Item ID:

D3535-15

Accept

Setup Start



Revision ID:

Item Name:

Wearshoe

Start Date: 10/6/2010 **Required Date:** 10/15/2010

Start Qty: 8.00

Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Accept

Qty

Start

Stop



QC:

Date:____

SPC (Y/N):

Set Up/

Date:

Stop

Number Stamp

Insp.

Sequence ID/ **Work Center ID**

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Memo

0.00

Run Hours

10/10/19

Tool ID

Code

Tool # Plan

Reject

Qty

Reject

170

Packaging Packaging

Identify as per dwg & Stock Location:

0.00

0.00

M wololia

13 0

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10 10 120 96)

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W/O:	N/O:			WORK ORDER CHANGES						
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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DATE	STEP	Description of NC Section A	Corrective Action Se		ion B		Verification Section C		Approval	
		Section A	Chief Eng	Chief Eng	Date	Secu	on C	Chief Eng	QC Inspector	
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Picklist Print

Wednesday, October 06, 2010 3:21:25 PM

Work Order ID: 62707

Parent Item: D3535-15

Parent Item Name: Wearshoe

Start Date: 10/6/2010

Required Date: 10/15/2010

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

Verified By:EC IPP Rev:B As per Rev B 07-08-31 JLM

	r											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date ·· Status Issued
M304S20GA 		Purchased	No			100	sf	108.6987	1.0205	8.593684		30-14
				<u>Location</u>		Loc C		Loc Code			~	
				MAT	114574	10.0	9522 6522			1=7/5	()	3)

Ī	<u>_ocation</u>	Loc Qty	Loc Code		_
N	ИAТ	85.9522			/ .~
	114574	10.6522			().
	115762	75.3		115762	
N	MAT20	22.7465		· · · · ·	
	112885	2.7475			
	113062	0.699			
	115440	19.3			

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DART AEROSPACE LTD	Work Order: (o 2 707
Description: Wearshoe	Part Number:	D3535-15
Inspection Dwg: D3535 Rev: B		Page 1 of 1

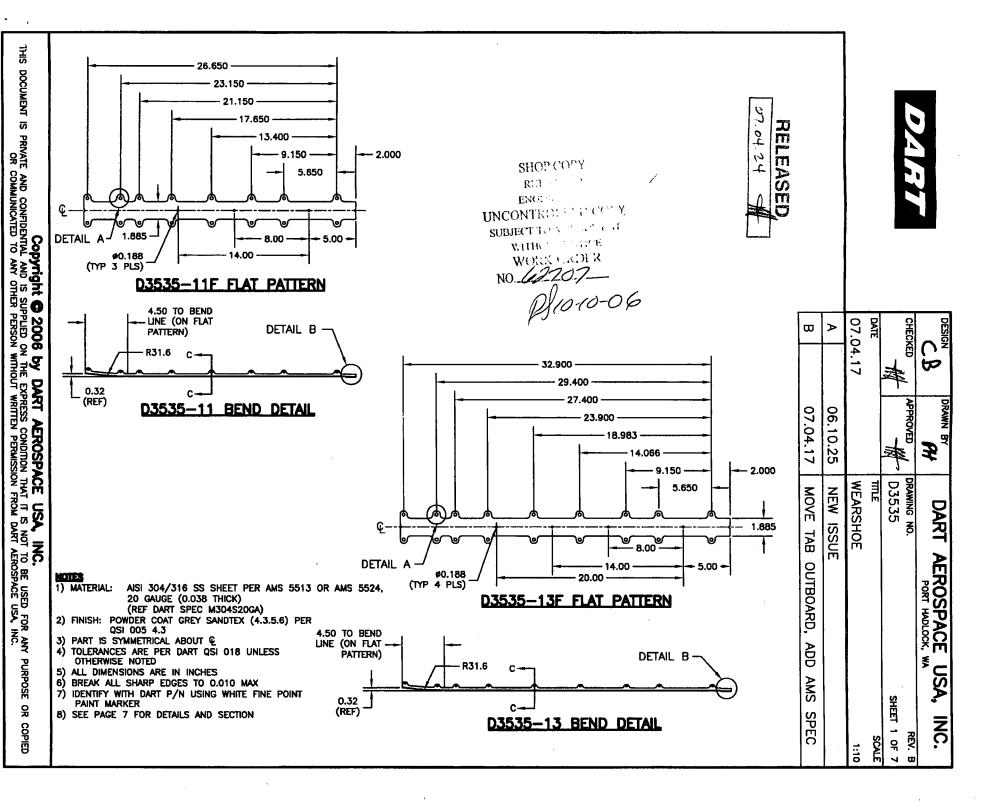
FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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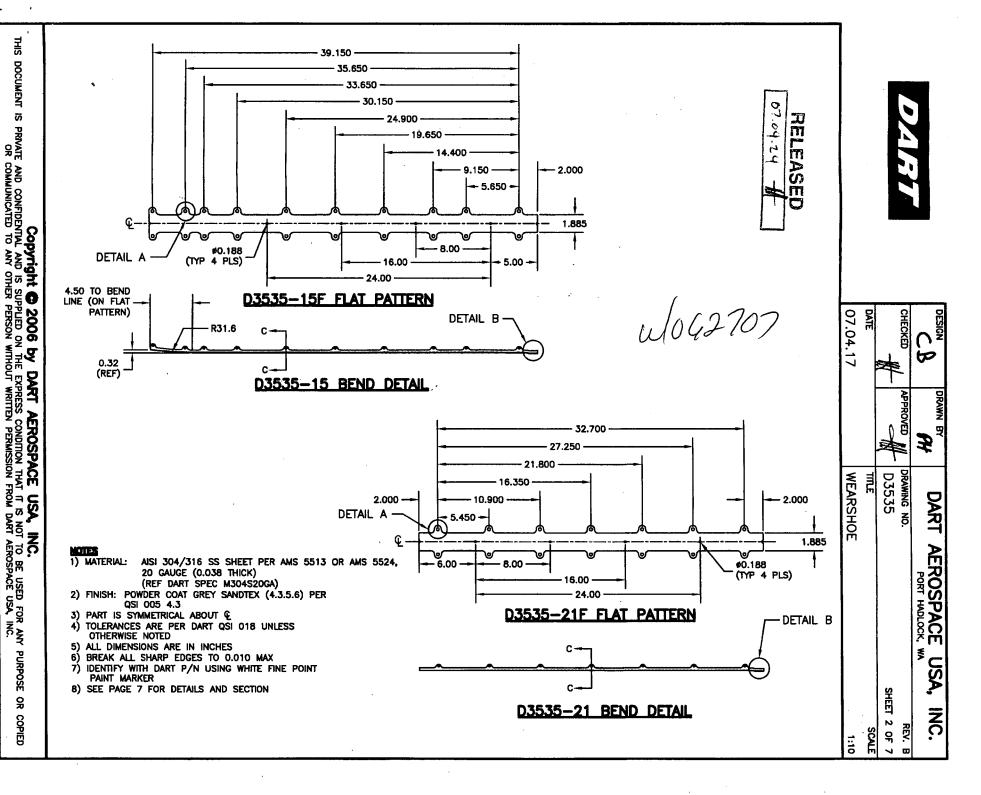
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5.650	+/-0.010	5,656	×		T 1801	
9.150	+/-0.010	9.150	*		7	
14.400	+/-0.010	14.400	*		7	
19.650	+/-0.010	14.650	* *		T	
24.900	+/-0.010	24,900	X		7	
30.150	+/-0.010	30.150	*		7	
33.650	+/-0.010	33,650	X		7	
35.650	+/-0.010	35.656	*		7	
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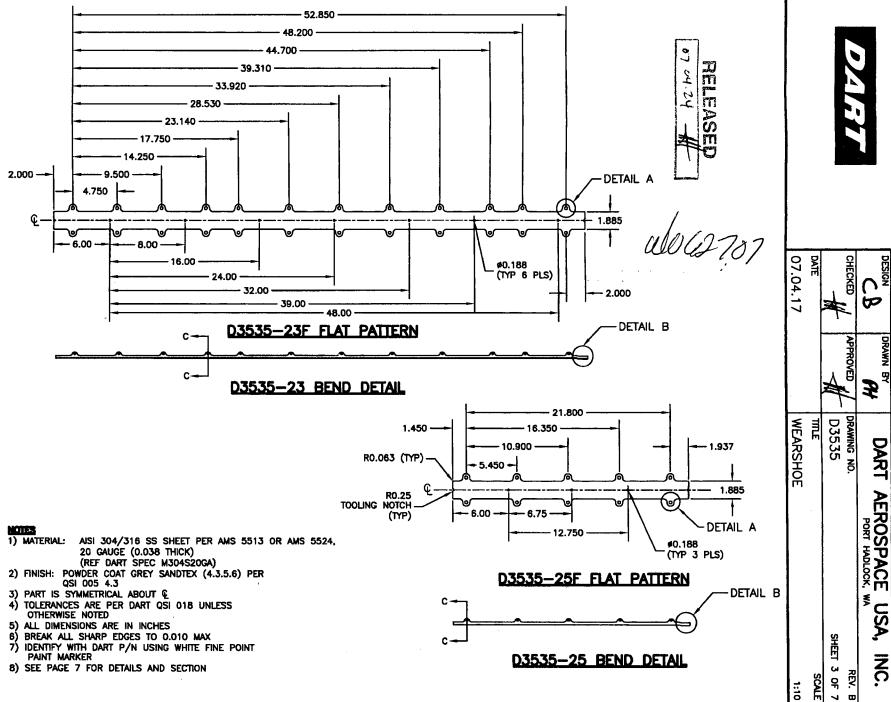
Rev	Date	Change	Revised by	Approved
Α	07.05.10	New Issue	KJ/JLM	E



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PURPOSE

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07.04.17





D3535-31F FLAT PATTERN

22.500 19.000

14.250

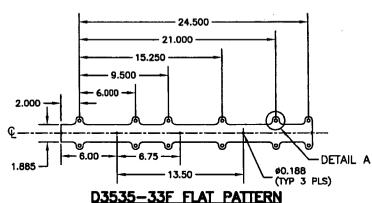
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ulo 62707





DETAIL A #0.188 (TYP 3 PLS)



NOTES

2) FIN

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PURPOSE

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4) TO

5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES TO 0.010 MAX
7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION

	13.50
13	D3535-33F F
ATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)	
INISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3	c—
'ART IS SYMMETRICAL ABOUT & OLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED	c

D3535 WEARSHOE DART AEROSPACE PORT HADLOCK. USA, SHEET RC. **수** 우 SCALE REV. 1:10

Dart Aeı	rospace	Ltd							
W/O:			W	ORK ORDER CHANGE	S				,
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		Description of NC		Corrective Action Section	n B	Verific	cation	Approval	Approval
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		Description of NC		Corrective Action Section B		Verification	Annroval	Approval
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DART

AEROSPACE PORT HADLOCK,

USA,

NO.

DRAWING NO.

SHEET

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SCALE OF 7

1:10

07.04.17 DATE

WEARSHOE

12.10 Ó

D3535-35F FLAT PATTERN

#0.188 (TYP 2 PLS)

-DETAIL A

23.250 19.750

17.750

9.500

4.750

2.000

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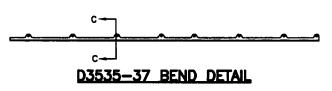
30.750 27.250 22.500 17.750 14.250 9.500 4.750 2.000 (A 1.885 -DETAIL A 16.00 21.00 ≠0.188 (TYP 4 PLS) D3535-37F FLAT PATTERN

		ШРБ
1) MATE	1)	MATE

AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)

(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3

- 3) PART IS SYMMETRICAL ABOUT &
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- PAINT MARKER



PURPOSE

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PRIVATE OR

5) ALL DIMENSIONS ARE IN INCHES

IDENTIFY WITH DART P/N USING WHITE FINE POINT

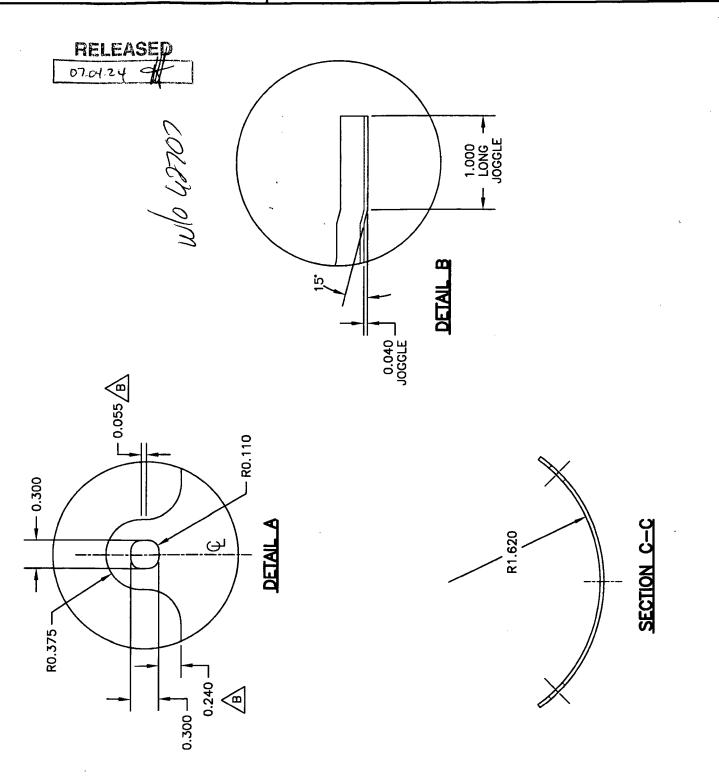
8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		-	WC	ORK ORDER CHANG	GES					
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC	Corrective Action Section				Verifi	cation	Approval	Approval
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DATE STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr QC I	oproval Inspector
Prod Mgr	
Part No: PAR #: Fault Category: NCR: Yes No DQA: Date:	
Resolution: Disposition: QA: N/C Closed: Date:	
NCR: WORK ORDER NON-CONFORMANCE (NCR)	
DATE STEP Description of NC Corrective Action Section B Verification Approval Ap	oproval
	Inspector



DESIGN	DRAWN BY	DART	AEROSPACE USA, INC.
CHECKED	APPROVED/	DRAWING NO.	REV. B
		D3535	SHEET 7 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:1



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DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr QC Ins Part No:PAR #: Fault Category: NCR: Yes No DQA: Date:	
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Part No: PAR #: Fault Category: NCR: Yes No DOA: Date:	
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